

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029394**Date Inspected:** 23-Mar-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site

CWI Name:	Bonifacio Daquinag and Bernie Docena			CWI Present:	Yes	No
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No N/A
				Delayed / Cancelled:	Yes	No N/A
Bridge No:	34-0006			Component:	SAS OBG	

Summary of Items Observed:

Caltrans Office of Structural Material (OSM) Quality Assurance Inspector (QAI) Joselito Lizardo was present at the Self Anchored Suspension (SAS) job site as requested to perform observations on the welding of components for the San Francisco Oakland Bay Bridge (SFOBB) Project.

At OBG 12W-PP116.5-W2 deck access hole outside, QA randomly observed ABF/JV qualified welder Lin E. Yun continuing to perform back welding fill pass on the Complete Joint Penetration (CJP) butt joint. The welder was observed manually welding in the 4G (overhead) position utilizing a Shielded Metal Arc Welding (SMAW) with 5/32" diameter E7018H4R electrode and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-1040C. The joint being welded has a single V-groove butt joint welded with steel backing bar. ABF Quality Control (QC) Bernie Docena was noted monitoring the welding parameters of the welder. QA randomly monitored the welding parameter with reading of 130 amperes which appears in conformance to the contract requirements. During the shift, SMAW fill pass welding was completed and the welder together with an apprentice ABF personnel performed flush grinding into the cover of the just back welded CJP butt joint plate.

At Bikepath panel point PP49, this QA randomly observed ABF welder Jose Torres perform all position fillet welding all around 2" x 2" x .25" angular and C channel C3 x 4.1 PS-3 pipe support. The welder was noted fillet welding the pipe support per ZPMC drawing BK-MEP-16 as replacement for the damaged same supports at panel points PP49 and PP89. During welding, the welder was noted using Shielded Metal Arc Welding (SMAW) with 1/8" diameter E7018H4R electrode implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-F1200A. ABF QC Bonifacio Daquinag was noted monitoring the welders' welding parameter and workmanship of the fillet welding. Since this was a replacement for the damaged pipe support, this QA had

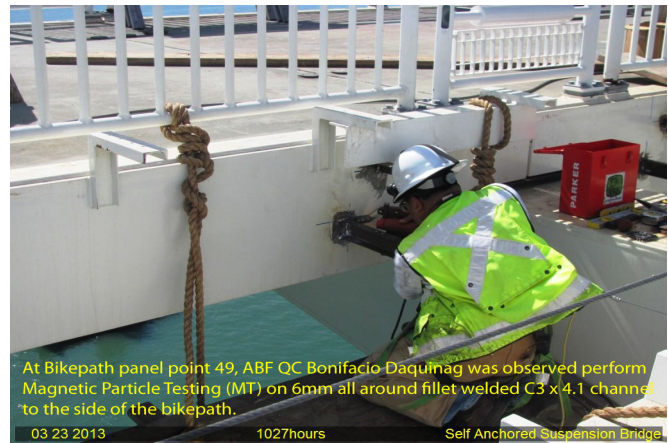
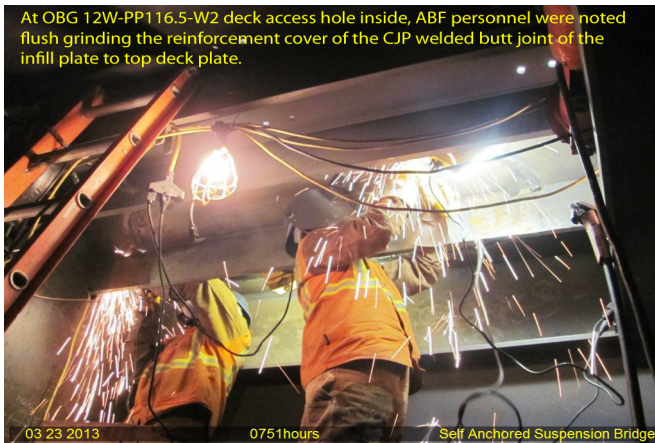
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followed up the Request for Information (RFI) for the pipe support being welded. QC had responded to this QA that so far they have not received one yet but already requested and still awaiting for the RFI. During the shift, ABF QC Bonifacio Daquinag performed Magnetic Particle Testing (MT) on the completely welded 6mm fillet all around the 2" x 2" x 0.25 angular and c-channel C3 x 4.1 to the side of the bikepath. The MT revealed no significant indications during the test.

At the request of Quality Control Field Supervisor, Bonifacio Daquinag, QA has randomly verified the QC MT on temporary welded lifting lug removal mentioned below. The QA verification was performed to verify that the VT/MT inspection performed by the QC inspector meet the requirements of the contract documents. At the conclusion of the QA verification it appeared that the ground removal of the lifting lugs and the QC inspection complied with the contract documents.

1. L14W-PP124.65-W3 South – OBG lifting lug (pyramid) removal QA verified
2. L13W-PP122.65-W3 South – OBG lifting lug (pyramid) removal QA verified
3. L13W-PP121.65-W3 South – OBG lifting lug (pyramid) removal QA verified



Summary of Conversations:

No significant conversation occurred today.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact SMR Gary Thomas 916-764-6027, who represents the Office of Structural Materials for your project.

Inspected By: Lizardo, Joselito

Quality Assurance Inspector

Reviewed By: Reyes, Danny

QA Reviewer
